

Work Order ID **77066**

77066

Page 1

November-25-11 8:24:44 AM

Item ID: D3234-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 11/25/11 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/28/11 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3234

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

Rev. C

181-12-12

⑧

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

181-12-12

Work Order ID 77066

77066

Page 2

November-25-11 8:24:44 AM

Item ID: D3234-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 11/25/11

Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/28/11

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

*Sumiz/13
@lwc*

(x6)

8XCP M-11/12/14

8 BR 11-12-14,

Work Order ID 77066

November-25-11 8:24:44 AM

77066

Page 3

Item ID: D3234-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 11/25/11 Start Qty: 8.00 ***8***

Cust Item ID:

Required Date: 11/28/11 Req'd Qty: 8.00 ***8***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: 233

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

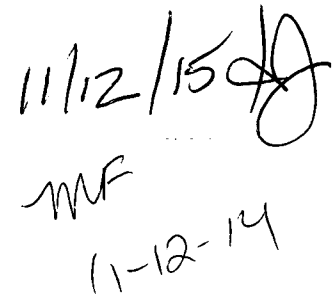
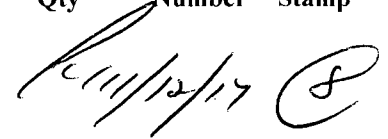
160

QC

Memo

0.00

Quality Control


MF
11-12-11

Picklist Print

November-25-11 8:24:44 AM

Page 1

Work Order ID: 77066

Parent Item: D3234-1

Parent Item Name: Doubler

Start Date: 11/25/11

Required Date: 11/28/11

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC
 IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC IPP REV:C 11.11.24 AS PER
 ECN11-674 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.080

2024-T3 080 sheet

Purchased

No

100

sf

204.3000

0.58

4.8842105

B(1-12)-12

Location

Loc Qty

Loc Code

MAT022

204.3

105411

6

109424

4

110347

0.5

112331

3

113796

7

114025

15.7

116604

5.8

117392

40.1

118180

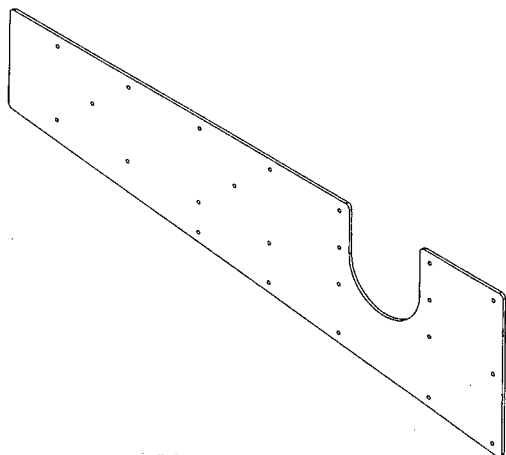
49.7

119117

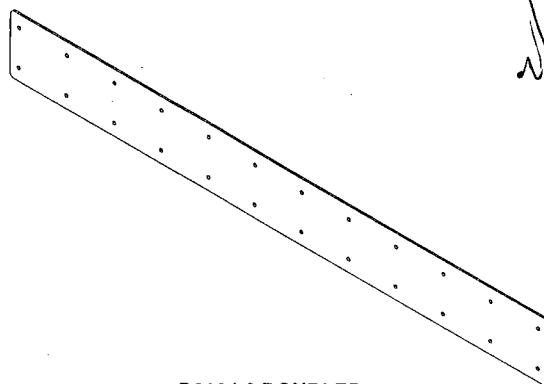
72.5

114025

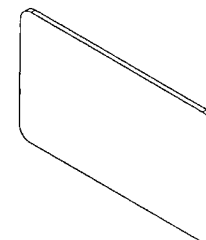
8



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

no 77066

RELEASED
2011-11-23

NOTES:

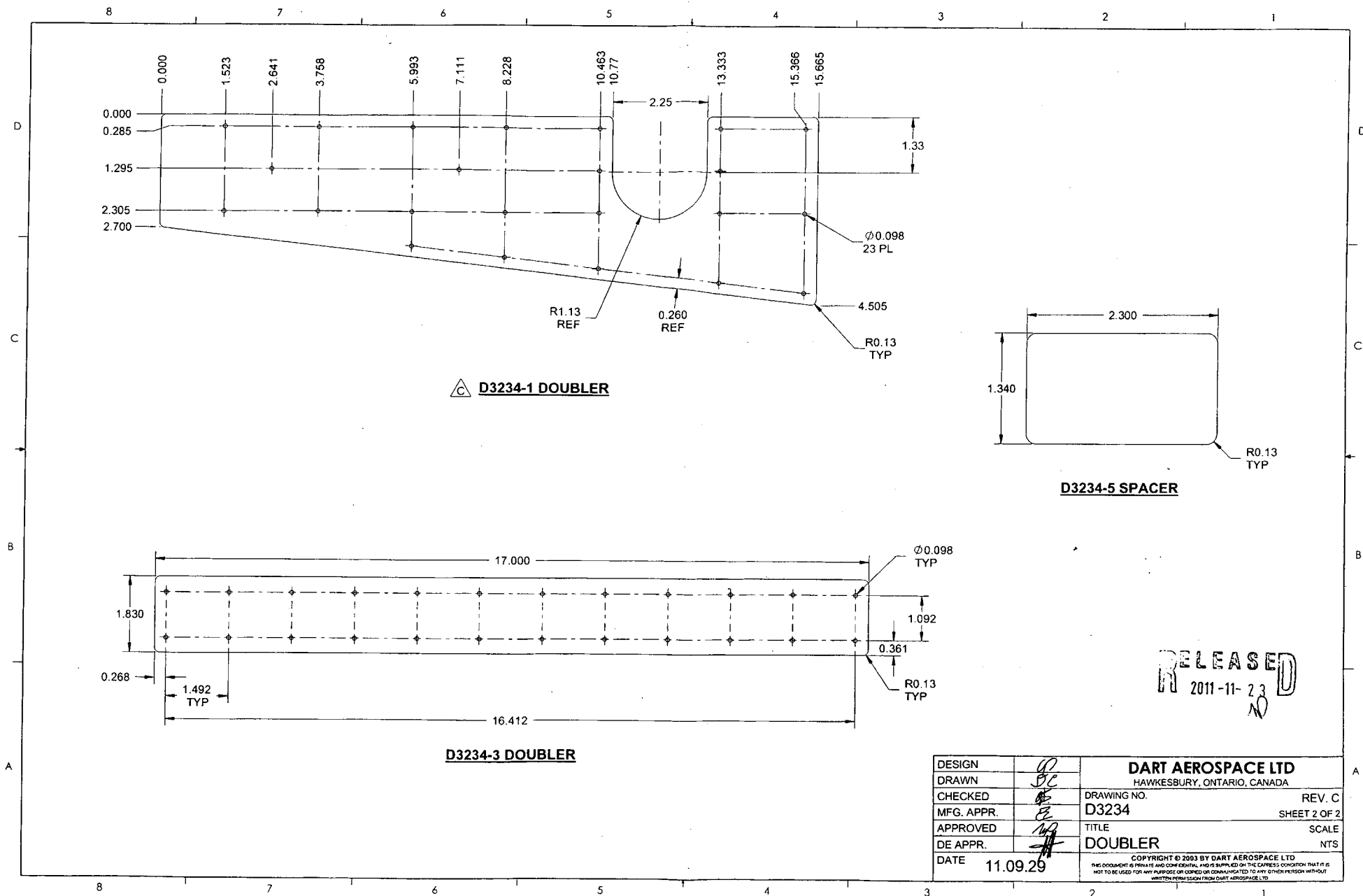
1) MATERIAL: -1: 2024-T3 ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.080

-3: 2024-T3 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: -1: 0.41 lbs
-3: 0.15 lbs
-5: 0.01 lbs

C	RE-DESIGNED D3234-1 TO FIT D3025-1 REV. B. ZONE C3-2, 4.505 WAS 5.347, ZONE D8-2, 2.700 WAS 2.841. REASON: REF PAR 11-118.	DC	11.09.29
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	DC	D3234	SHEET 1 OF 2
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	DOUBLER	NTS
DATE	11.09.29	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



RELEASED
2011-11-23
N

FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD		Work Order: 77066
Description: Doublet		Part Number: D3234-1
Inspection Dwg: D3234 Rev: C		Page 1 of 1

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of inspection	Comments
---------	-----------	-----------	--------	--------	--------	----------------------	----------

Ø	1.098	+ .004 - .001	1.098	✓		✓	1.098
	1.285	± .010	1.287	✓		✓	
	1.295	± .010	1.295	✓		✓	
	2.305	± .010	2.308	✓		✓	
	2.700	± .010	2.704	✓		✓	
	4.505	± .010	4.502	✓		✓	
	1.33	± .030	1.33	✓		✓	
	1.523	± .010	1.523	✓		✓	
	2.641	± .010	2.646	✓		✓	
	3.758	± .010	3.758	✓		✓	
	5.993	± .010	5.993	✓		✓	
	7.111	± .010	7.110	✓		✓	
	8.228	± .010	8.228	✓		✓	1.001
	10.463	± .010	10.463	✓		✓	
	10.77	± .030	10.777	✓		✓	
	2.285	± .010	2.246	✓		✓	
	13.333	± .010	13.333	✓		✓	
	15.346	± .010	15.346	✓		✓	
	15.665	± .010	15.665	✓		✓	
	1.090	± .010	1.078	✓		✓	

Measured by: 18	Date: 11-12-12	Audited by: S	Date: 11/2/15	Prototype Approval:	Date:
Rev	Date	Change	Revised by	Approved	KJ/LLM